

Work Order ID 77034

77034

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November-24-11 3:39:55 PM

Item ID: D2274 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Radius Block
 Start Date: 24/11/2011 Start Qty: 200.00 *200* Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 200.00 *200* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/25 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2274	Rev F								

100 0.00
 100 SHEAR
 Shear Memo 0.00
 Shear blanks 9.00" long +/- 0.030" Note: 1 blank makes 9 pieces

110 0.00
 110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Machine as per folio D2274

120 0.00
 120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							11/12/11 (200)
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST 10</u> Memo	0.00 0.00							(200) SP 11-12-21
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/12/22 J MF 11-12-22

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Picklist Print

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Parent Item: D2274

D2274

Parent Item Name: Radius Block

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP H00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B00750X00.1 25		Purchased	No			100	f	123.7500	0.0916	19.28421			

M6061T6B00750X00 125

**

24 11.12.13

6061-T6 Bar .750 x .125

Location

Loc Qty

Loc Code

MAT001

43.75

116406 ✓

2.75

117653 ✓

40.5

118641 ✓

0.5

MAT003

80

119653

80

116700

16.041
5
5

Dart Aerospace Ltd

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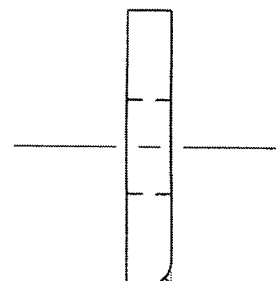
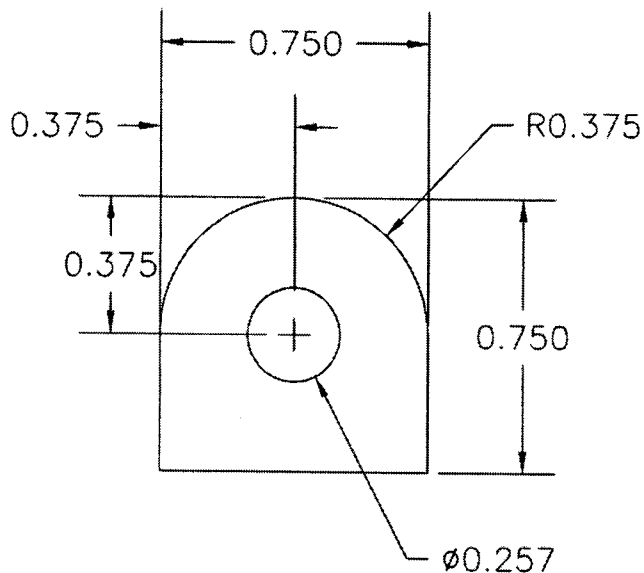
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RELEASED
98/08/18 KE

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2274	REV. F SHEET 1 OF 1
DATE 98.08.11		TITLE RADIUS BLOCK	SCALE 2:1
A	94.09.29	NEW ISSUE	
C	95.07.12	RADIUS ENDS	
D	97.03.24	ADD MATERIAL SPECIFICATION	
E	97.12.12	ADD FINISH & TOLERANCE QSI	
F	98.08.11	R0.0 - 0.13 WAS R0.063 - 0.125	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77034 M.C.J
11/11/25

00.05.16
00.05.16
0.063 x 45° CHAMFER
R0.0 0.13

MATERIAL: 5052-H34 (QQ-A-250/8) 0.125 THICK
OR 6061-T6 (QQ-A-250/11) 0.125 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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